

Need finished for Monday June 4

Work Order ID 85036

May-31-12 3:14:44 PM

85036

Page 1

Item ID: D2196-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 31/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/31 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2196

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2196 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

2

0

Jm

12-6-01

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2

0

Jm

12-6-01

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

2

0

Jm

12-6-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per dwg D2196								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: <i>G-A</i>								
Packaging	Memo	0.00							
Packaging									

Schulder

5/2/06/01

P 12/06/04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 31/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/12

MF
12-06-06

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Picklist Print

May-31-12 3:14:48 PM

Page 1

Work Order ID: 85036

85036

Parent Item: D2196-2

D2196-2

Parent Item Name: Bracket

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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No

**

**

0.4016 SF

304 0.063"

B# 121626

JM
12-~~0~~01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25036
Description: Bracket		Part Number:	D2196-2
Inspection Dwg: D2196	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.128"	✓		✓	mm01
Ø0.203	+0.005/-0.001	0.203"	✓		✓	
Ø0.316	+0.006/-0.001	0.316"	✓		✓	
0.375	+/-0.010	0.381"	✓		✓	
0.813	+/-0.010	0.816"	✓		✓	
1.750	+/-0.010	1.759"	✓		✓	
2.688	+/-0.010	2.689"	✓		✓	
3.625	+/-0.010	3.634"	✓		✓	
4.000	+/-0.010	4.009"	✓		✓	
0.375	+/-0.010	0.382"	✓		✓	
1.200	+/-0.010	1.204"	✓		✓	
2.390	+/-0.010	2.394"	✓		✓	
3.960	+/-0.010	3.967"	✓		✓	
5.530	+/-0.010	5.538"	✓		✓	
6.730	+/-0.010	6.739"	✓		✓	
7.230	+/-0.010	7.234"	✓		✓	

Measured by:	JM
Date:	12-8-01

Audited by:	W/W
Date:	12-06-01

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

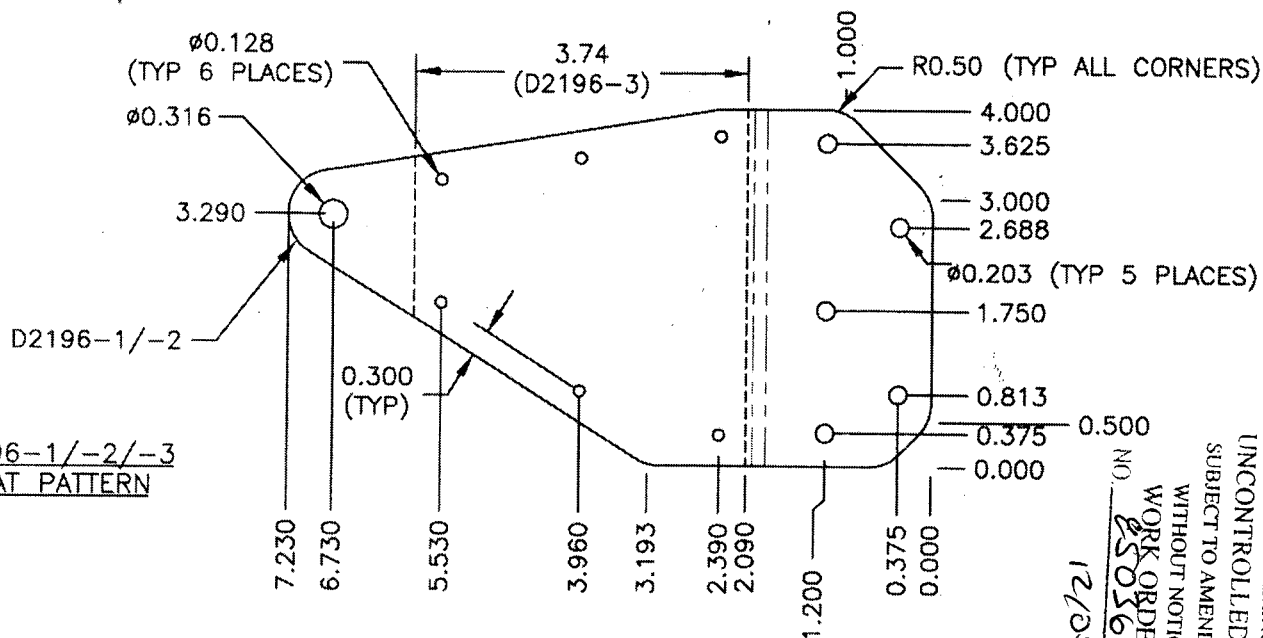
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2196	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2196-3 NOW 0.5" THICK	



D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2196-3

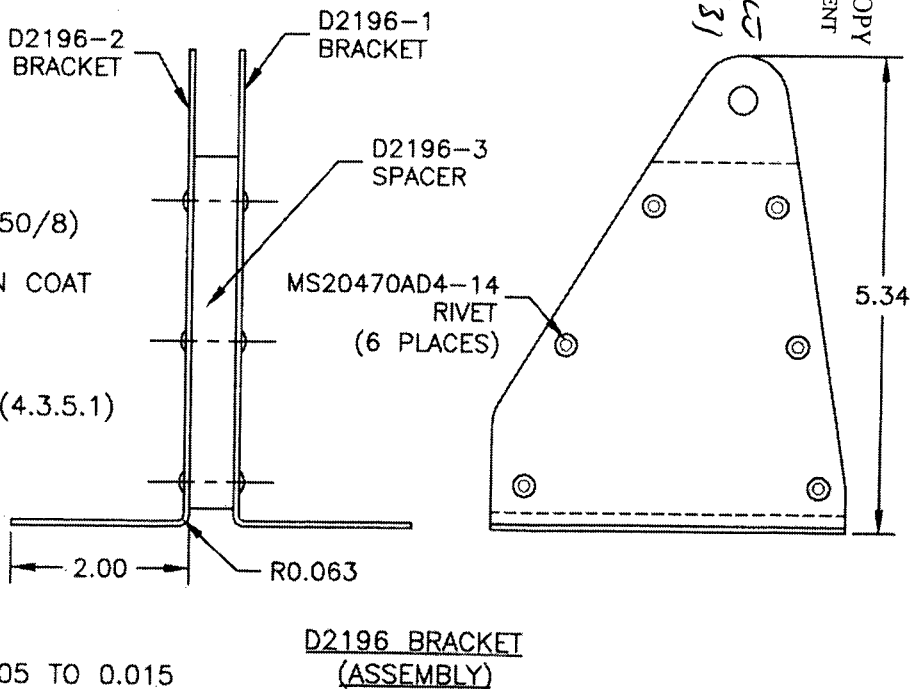
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25056445
12/05/31

SHOP COPY

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Dart Aerospace Ltd

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